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D3201-3
Job Sheet 186937



Part No: D3201-3

Job Qty: 6 ea

Part Name: Angle



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/22/18

Job Tracking No:

Due Date: 12/3/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev: A Removed from 9 Digit 06-01-25 JLM IPP Rev:B Now on Waterjet 06-08-14 JLM IPP Rev C added scribing NCR262 07.11.29 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	6 pcs	12/3/18	12/3/18	0.00	0.09	Waterjet - Flow		SCB 11/29
120	QC	6 pcs	12/3/18	12/3/18	0.00	0.00	QC8		38
140	Brake NC	6 pcs	12/3/18	12/3/18	0.05	0.14	Brake NC 1		D9-89 DAS
150	QC	6 pcs	12/3/18	12/3/18	0.00	0.00	QC5		38 30
160	HandFinish	6 pcs	12/3/18	12/3/18	0.00	0.15	HandFinish1		DR 18/12/19
170	QC	6 pcs	12/3/18	12/3/18	0.00	0.00	QC7-2		DAS 38
180	Packaging	6 pcs	12/3/18	12/3/18	0.00	0.00	Packaging3-1	51023	6 DAS 9-89
190	QC21-SA	6 Ea	12/3/18	12/3/18	0.00	0.00	QC21		9-89 21 9-89 DEC 21 2018

Part Op 100 - 1-Cut as per Dwg D3201 (CHECK GRAIN DIRECTION BEFORE CUTTING) (CHECK GRAIN DIRECTION
Descriptions: BEFORE PASSING IN DEBBURING MACHINE)
140 - 1-Bend as per Dwg D3201

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.050	2024-T3 .050 Sheet	.2700 sf (.045 ea)	100-Waterjet - Flow - 1	M137626

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.050	0	34	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	3.760inches ± 0.030	3.790 3.730	3,761	
2	Doubler	3.460inches ± 0.030	3.490 3.430	3,462	
3	Doubler	1.680inches ± 0.030	1.710 1.650	1,683	
4	Doubler	0.050inches ± 0.010	0.060 0.040	0,050	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering Quality ☐ Other ☐			
Date : _____		Step #: _____		Container No: S133321 Part: D3201 - 3 Job No: 186937 Serial No/Batch: S133321 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 11/29/18			
Description Work Order Deviation							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Fo ☐ Bending ☐ Centre Not ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ ned Wrong ☐ e Dimensions ☐ over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : _____					